

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022888**Date Inspected:** 18-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** ShangHai, China**CWI Name:** Sha Zhi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance(QA) Inspector, DJ Shin was present during the times noted above for observations relative to the work being performed.

Bay 11

This QA Inspector observed the following work in progress for Bay 11.

ZPMC was using the Shield Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Wang Chuang Xin.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector

Components: Tower Lift 6

PCMK: WSD1-TL6-4A/D-1, 4

Welder: 041271

WPS-B-P-2112

PCMK: ESD1-TL6-2A/D-1, 4

Welder: 040614

WPS-B-P-2112

Components: Traveler Rail

PCMK: 25TR1-002-016

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Welder: 044541
Report: B-WR20599
WPS-345-SMAW-2G (2F)-Repair-1

PCMK: 34TR1-001-009
Welder: 044551
Report: B-WR20598
WPS-345-SMAW-2G (2F)-Repair-1

Trial Assembly Yard

This QA Inspector observed the following work in progress for Trial Assembly Yard.

ZPMC was using the Shield Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Li Yang

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector

Components: OBG 13 West Line
PCMK: SA7512-001-024
Welder: 047869
Report: C-WR2927
WPS-345-SMAW-3G (3F)-FCM-Repair-1

Components: OBG 12 West Line
PCMK: SEG3013V-102
Welder: 066674
WPS-B-P-2212-TC-U4b-FCM-1

PCMK: EP3020-001-002, 007, 008
Welder: 067611
WPS-B-P-2112-FCM-1

This QA Inspector observed the following work in progress for Trial Assembly Yard.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Li Yang.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specifications (WPS). Listed below are the locations that were identified by this QA inspector.

Components: OBG 12 West Line
PCMK: 12CW+13AW X4389B
Welder: 203871
Report: B-WR20667
WPS-345-FCAW-1G (1F)-ESAB-FCM-Repair-1

This QA inspector performed Magnetic Particle Testing (MT) and Visual Inspection (VT) of approximately 15 %

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) is/are identified as follows; OBG13 East Line, on item number 5 of NWIT tracker document # 08860,

And OBG12 East Line, on item number 1& 2 of NWIT tracker document # 08863,

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Shin,DJ

Quality Assurance Inspector

Reviewed By: Riley,Ken

QA Reviewer